Dart Aerospace Ltd.

Date: Tuesday, 10/3/2006 3:47:09 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: GASKET
Job Number	: 28853		
Estimate Number	: 10431		
P.O. Number	: N/A	**Part Number**	: D3255
This Issue	: 10/3/2006 **S.O. No.** : N/A	**Drawing Number**	: D3255 REV B
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : PURCHASED PARTS	**Drawing Revision**	: B
Previous Run	: 26473	**Material**	: N/A 54 SF
Written By	:	**Due Date**	: 10/16/2006 **Qty:** ~~30~~ 54 **Um:** Each
Checked & Approved By	: 06 10 03		
Comment	: Est A 04.04.06 New issue KJ/RF		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING

Comment: PURCHASING
Issue P/O: 2177 c Locel 10104
Email or Ship DXF file to vendor
Possible Supplier: Beuco Inc.
Material: Silicone coated fiberglass cloth per AMS 3320F
P/N: SIL/F 36' x 36' x 1/16"
Material release note is required
(54)

2.0	SILF36X36X116	Gasket

Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)
GASKET

3.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Recieve & Inspect for Transit Damage
Ensure Material Release Note is attached
PC 4/12/04 6 mcp
~~06/10/17~~ (54)

4.0	QC6	DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK
PC 6.12.12 54 pcs

5.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST 34 S
PC 6/14/12 (54)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** LP **Date:** 06/12/13

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Tuesday, 10/3/2006 3:47:09 PM
User: Kim,Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** GASKET

Job Number: 28853 **Part Number:** D3255

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC21	FINAL INSPECTION/W/O RELEASE

(54)

Comment: Inspection Level 21

06/12/13

Job Completion

06.12.13

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

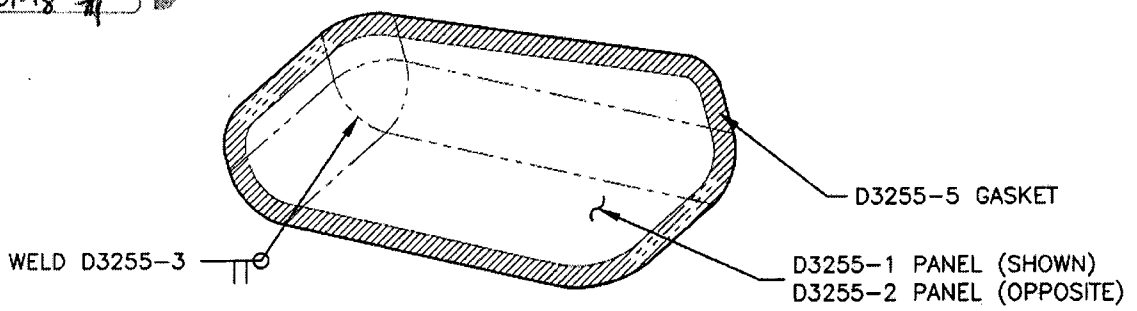
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

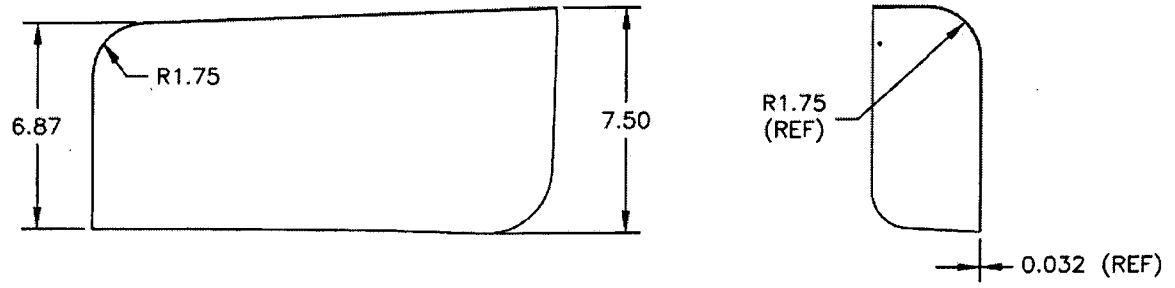
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6

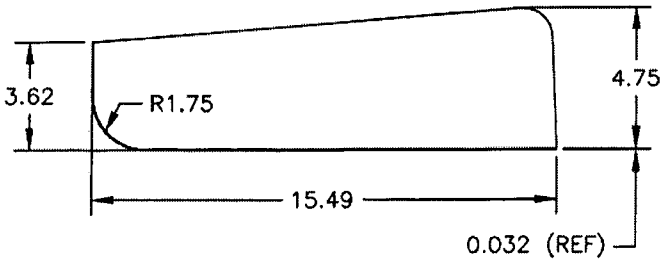
A	04.01.27	NEW ISSUE
B	04.12.06	D3255-3 REDESIGN; ADDED ø0.098

RELEASED
05-01-18



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)





D3255-1 BEND DETAIL
D3255-2 OPPOSITE

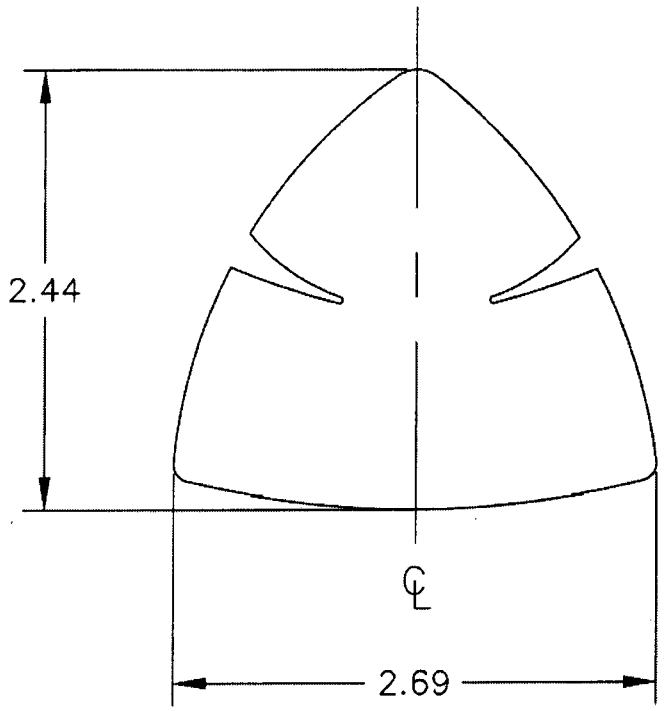
SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 28853

D3255-041/-042 NOTES:
1) WELD PER DART QSI 004
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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		D3255	SHEET 2 OF 4
DATE		TITLE	SCALE
04.12.06		TITLE	1:1

RELEASED
05.01.18



D3255-3 CAP
FORM TO FIT D3155-1/-2

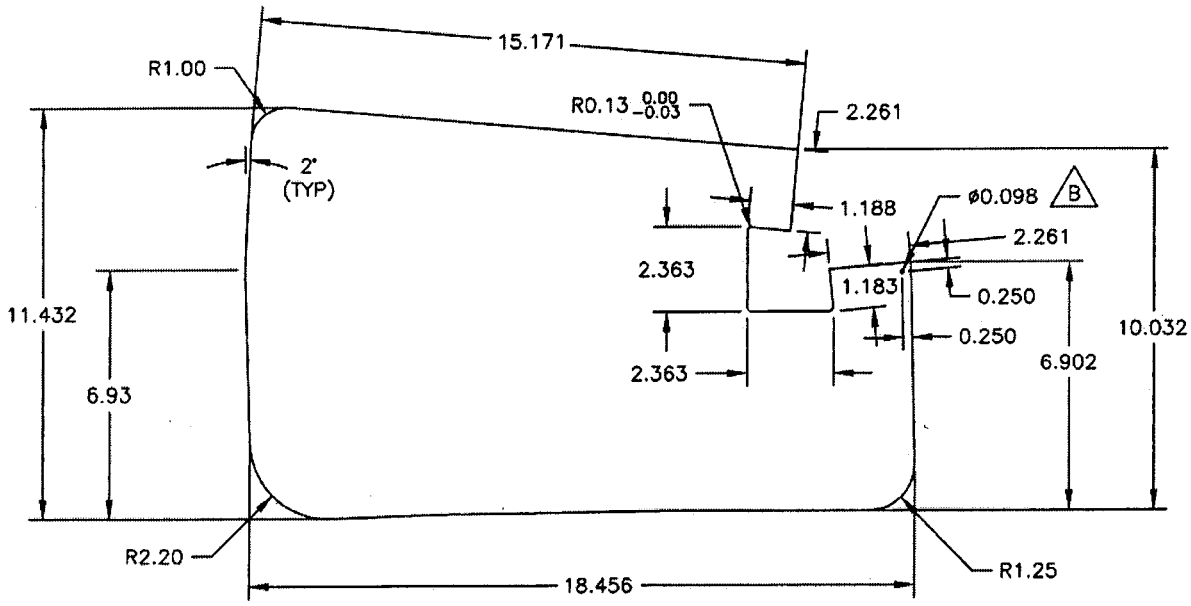
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WORK ORDER NO. 28853

D3255-3 NOTES:
1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010
6) MAKE PER DRAWING "D3255-B2.DWG"

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DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

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05-01-18



D3255-1/-2 FLAT PATTERN

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NO. 28853

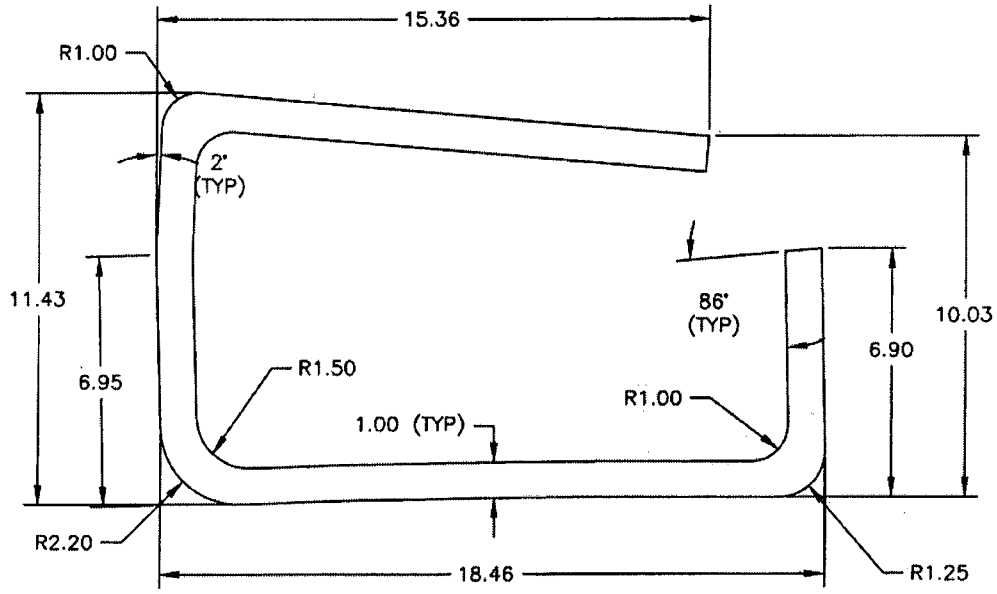
D3255-1/-2 NOTES:

1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED	APPROVED	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18



D3255-5 GASKET

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28853

D3255-5 NOTES:
1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLER: AVIALL
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES

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GT MIDWEST
A DIVISION OF GT SALES & MANUFACTURING, INC.
2202 S WEST ST
WICHITA, KS 67213
VOICE: (316)943-2171
FAX: (316)943-4800

PACKING SLIP

*** PACKING SLIP ***

TAKEN BY	ORDER #
RSN	10108611-00

ORDER DATE	CUSTOMER PO #	PAGE
10/20/06	0610074	1

CUST.# 106746

BILL TO: BEUCO INC
776 NORTH BELL AVENUE
CHESTERFIELD, MO 63005
UNITED STATES

CORRESPONDENCE TO: GT MIDWEST
PO BOX 755
WICHITA, KS 67201-0755

SHIP TO: DART AEROSPACE LTD
1270 ABERDEEN ST.
CANADA
HAWKESBURY, ON K6A 1K7
UNITED STATES

SHIP POINT	INSTRUCTIONS
GT MIDWEST - WICHITA	

SHIP VIA	REQUEST DATE	PICKED	TERMS
FEDX 2D-ADD	10/27/06	11/28/06	2 % 10 N 30

LINE NO.	PRODUCT AND DESCRIPTION	BIN LOCATION	QUANTITY ORDERED	QUANTITY B.O.	QTY. SHIPPED	U/M	RECEIVED	NO. CTNS
	THIS ORDER IS CONTAINED IN THE FOLLOWING CARTON(S): C000301751							
1	RS9865 36"SQ RD SIL/FBRGL REINF STRIP(RS1075) TO AMS3320 CARTON #: C000301751 QTY: 6.00 EACH MUST SEND CERT TO AMS3320		6.00	0.00	6.00	EACH		

P/O 2177

LAST PAGE

SEE TERMS AND CONDITIONS ON THE BACK

Seller represents that these goods or services comply with all applicable requirements of the Fair Labor Standards Act as amended and of regulations and orders of the U.S. Department of Labor issued under Section 14 thereof.

1	LINES TOTAL	# OF LINES NOT PRINTED	0	QTY. SHIPPED TOTAL	6.00

PICKED BY	PACKED BY	CHECKD BY	CUBE	WEIGHT	FREIGHT CHARGE
			6.00000	0.00000	

RECEIVED BY	DATE RECEIVED

GT MIDWEST OBJECTS TO, AND REJECTS, ALL TERMS CONTAINED IN THE BUYERS ACCEPTANCE THAT ARE DIFFERENT OR ADDITIONAL TO THE TERMS CONTAINED IN GT MIDWEST PRICE QUOTE AND INVOICE. UNLESS NOTIFIED BY GT MIDWEST, IN WRITING, GT MIDWEST WILL CONTINUE TO PERFORM THE CONTRACT SOLELY IN ACCORDANCE WITH THE TERMS SET OUT IN THE PRICE QUOTE AND INVOICE.

KS 1075

SAINT-GOBAIN
PERFORMANCE PLASTICS

Saint-Gobain Performance Plastics
14 McCaffrey Street
P.O. Box 320
Hoosick Falls, NY 12090
(518) 686-7301 Fax (518) 686-4840

Date: 24-Jun-05

Product Specification Certification with Test Report

Purchase Order: 1002341-00
Customer Spec: Standard
Product: 3320 1/16
Lot Number: 1896809
Quantity: 12 ly

To: G T SALES & MFG. INC.
2202 SOUTH WEST ST
WICHITA, KS 67213

Property	Test Method	Units	Tested Value	Specification Minimum	Specification Maximum
Durometer	Internal	Duro	70	70	74
Oil Burst	Internal	Lbs	690	350	
Tensile Fill	ASTM D 412	psi	369	100	
Tensile Warp	ASTM D 412	psi	410	350	
Thickness	ASTM D-374	in	0.0640	0.0575	0.0675
Weight	Internal	Grams	14.4		

Comments: 36.0i DOM 04/05 - Shelf Life 10 years from date of shipment - Meets AMS3320

Very Truly Yours,
Saint-Gobain Performance Plastics

Elaine Weeden

Elaine Weeden

Quality Assurance Department

This is to certify that the above designated material has been tested for and does comply with listed physical properties when supplied in the original container. The material is subject to the conditions listed on the invoice. The above is a copy of information on file. The lot acceptance data are available for examination.